

Date: Thursday, 11/06/2009 11:55:51 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 48496	
Estimate Number : 13374	
P.O. Number :	Part Number : D37695
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3769 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 43194	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.06.11</u>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
		(10X)
Comment: Qty.: 1.7579 f(s)/Unit Total: 17.5791 f(s) * M 109 850 (2X) M 111029 (4X) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M 111029 (2X) M 110778 (2X) M-L 09/06/12</u>		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		(10X)
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to length as per dwg D3769 2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr <u>M-L 09/06/12</u>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>S 09/06/15 (10X)</u>		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		(10X)
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>UMD 09/06/15</u>		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>09-06-15 (10X)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:55:52 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 48496

Part Number: D37695

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



102
SD

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 250 A

8/6/16

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/17 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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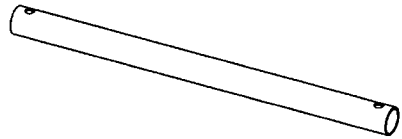
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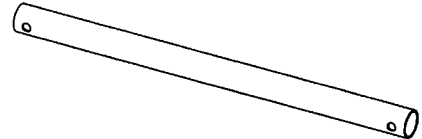
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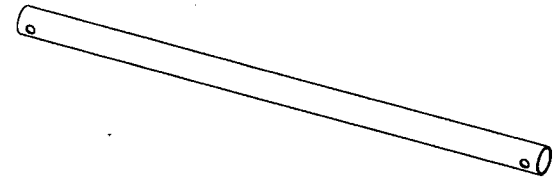
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D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

RELEASED
08.06.04

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

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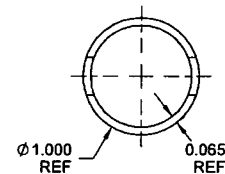
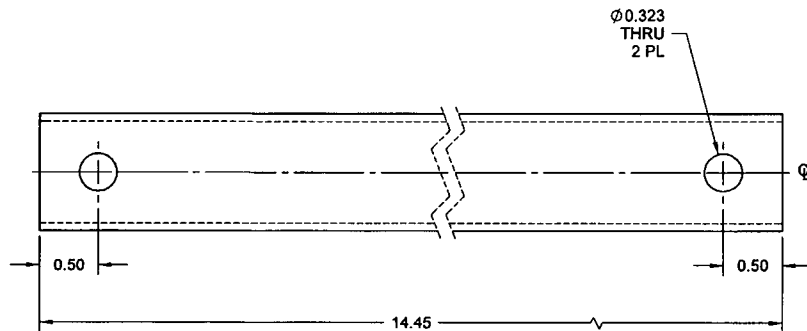
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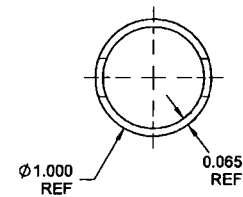
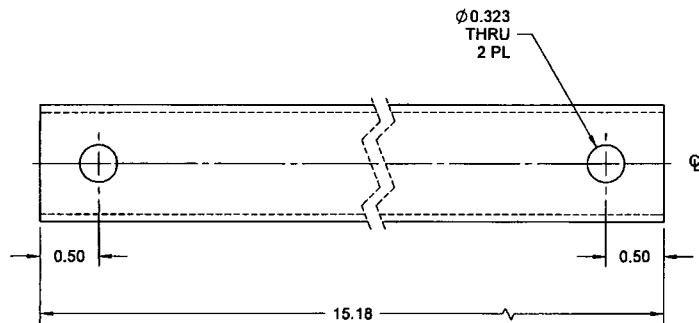


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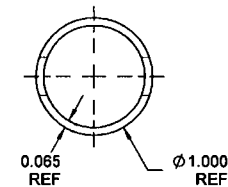
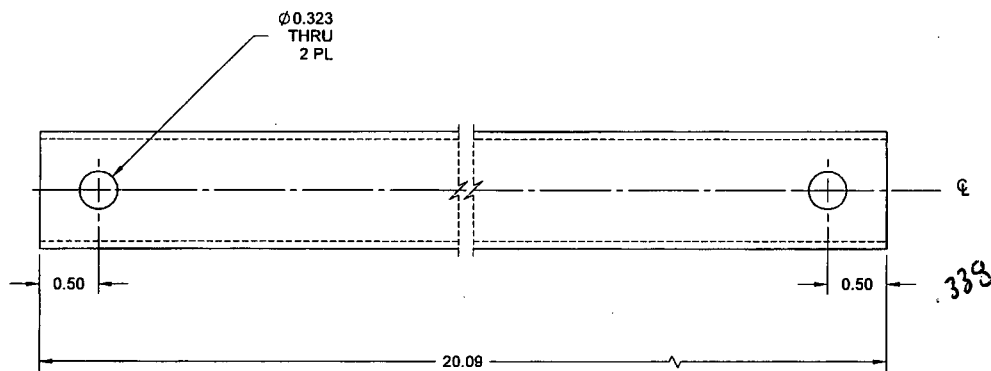


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D3769-5 TUBE

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